

ABSTRACT OF THE DISCLOSURE

While at least one of first and second tools **4** and **5** of a junction tool **6** is rotated, a workpiece **W** made of a plurality of plate materials **W1** and **W2** superimposed in their thickness directions is nipped between the first and second tools and joined at points. The first tool **4** is provided with a pin **44** protruding from its distal end surface **43** along a junction axis **X**. The second tool **5** is provided with a depression **51** which is depressed at its distal end surface **53** along the junction axis **X**. By the first pin **44** of the first tool **4** and the depression **51** of the second tool **5**, the superimposed surface **W3** of the softened workpiece **W** is caulked in the direction of the junction axis **X**. Further, plastic flow is generated within the workpiece **W** so as to agitate the vicinity of the superimposed surface **W3**.